

GKN Driveline International GmbH  
Hauptstrasse 130  
53797 Lohmar

26 November 2004  
Ne/bec (20040423)  
Q04029W000

**Process of machining outer joint parts or inner joint parts  
with pairs of tracks  
extending parallel relative to one another, wherein  
said pairs of tracks are machined simultaneously**

#### Abstract

A process of machining outer joint parts 11 and inner joint parts 21 of constant velocity universal ball joints, which outer joint parts 11 and inner joint parts 21 each comprise a longitudinal axis and a number of ball tracks 12, wherein the ball tracks are each arranged circumferentially in pairs 12<sub>1</sub>, 12<sub>2</sub>, whose central track lines are positioned in planes E<sub>1</sub>, E<sub>2</sub>, E<sub>3</sub>, E<sub>4</sub> extending parallel relative to one another, wherein the pairs of ball tracks 12 are machined by rotating disc tools 16 whose axes of rotation R perpendicularly intersect the respective longitudinal axis at a distance from one another and are held and guided coaxially relative to one another.

Figure 1